

Work Order ID 132373

132373

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Monday, May 25, 2015 11:51:49 AM

Item ID: D044-662-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: R44 Bearpaws
 Start Date: 4/29/2015 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 5/7/2015 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: MAY 25 2015 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D044-662	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo <u>M. 10</u>	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD044-662-011 CHG004								
						DAS 6 9-89			ML5 15-05-26 DAS 02 9-89 15-06-08
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
						3x	DAS 28 9-89		JUN 08 2015 MAY 25 2015
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									
						DAS 6 9-89			DAS 02 9-89 15-06-08

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Item ID: D044-662-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: R44 Bearpaws

Stop *NS2*

Start Date: 4/29/2015 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/7/2015 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D044-662-011 LOCATION: FG014								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

F6014

DAS
6
9-89

(3)
JUN 08 2015

MLJ JUN 10 2015

MLJ JUN 09 2015

Picklist Print

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Work Order ID: 132373

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Parent Item: D044-662-011

D044-662-011

Parent Item Name: R44 Bearpaws

Start Date: 4/29/2015

Required Date: 5/7/2015

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:C04.02.19Added tolerance and ref to DSK086-12 to Step 3KJ/JLM
IPP Rev:D As per ECN 932 & 862 06-07-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4953-1		Manufactured	No			110	Each	4.0000	4	12			
---------	--	--------------	----	--	--	-----	------	--------	---	----	--	--	--

D4953-1

Cush

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST545

4

131442

4

D3075-1

Manufactured No

110

Each

1.0000

2

6

D3075-1

Bearpaw(Foot Print Only)

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST

1

130315

1

D2529

Manufactured No

110

Each

58.0000

8

24

D2529

Washer

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST008

58

128950

58

D3556-1

Manufactured No

110

Each

6.0000

4

12

D3556-1

Clamp For R44 Bearpaw

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST542

6

132801

6

B133323 X 4
B132899 X 8

JUN 05 2015

132564

B132564 X 6

JUN 05 2015

24

6X B133207

6X

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Parent Item: D044-662-011

D044-662-011

Parent Item Name: R44 Bearpaws

Start Date: 4/29/2015

Required Date: 5/7/2015

Start Qty: 3.00

Required Qty: 3.00

D3601-1 Manufactured No

110 Each 154.0000 8 24

D3601-1

Radius Block

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST051

154

131981

30

132769

124

**

DAS
28
9-89

MAY 25 2015

DAS
27
9-89

DAS
02
9-89

24

AN4-14A Purchased No

110 Each 424.0000 4 12

AN4-14A

Bolt

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

5

122141

5

ST325A

307

131677

2

M131153

5

M132189

100

M132317

200

ST344

112

M130716

15

M131803

97

**

DAS
28
9-89

DAS
27
9-89

DAS
02
9-89

12

AN4-15A Purchased No

110 Each 354.0000 4 12

AN4-15A

Bolt

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

38

120449

38

ST325A

316

m130358

8

m131320

13

m131957

95

m132317

200

**

DAS
28
9-89

DAS
27
9-89

DAS
02
9-89

12

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Work Order ID: 132373

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Parent Item: D044-662-011

D044-662-011

Parent Item Name: R44 Bearpaws

Start Date: 4/29/2015

Required Date: 5/7/2015

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0463J

Purchased

No

110

Each

5,702.000

8

24

NAS1149D0463J

WASHER

DAS
28
9-89

DAS
27
9-89

MAY 25 2015

**

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

GA	41
M129390	41
ST260a	2000
M132317	2000
ST269	3661
M129682	86
M130799	371
<u>M132035</u>	3204

24

DAS
02
9-89

MS21042L4

Purchased

No

110

Each

2,767.000

8

24

MS21042L4

Locknut

DAS
28
9-89

DAS
27
9-89

DAS
02
9-89

**

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001	26
m124231	26
GA	224
m127813	224
ST260a	1062
m130799	56
m131803	6
m132262	1000
ST305	1455
m128300	8
m130388	7
m130922	97
m131618	12
<u>m132123</u>	1331

24

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4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-662-011 Bearpaw Installation	4.6 lb 2.10 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.1 in 3.25 m	589 in-lb 6.8 m-kg
D044-662-013 Bearpaw Installation	6.2 lb 2.81 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	129.1 in 3.28 m	800 in-lb 9.2 m-kg
D044-662-041 Wearplate Kit (installed on D044-662-011/-013 Bearpaw Kit)*	1.6 lb 0.73 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.3 in 3.26 m	205 in-lb 2.4 m-kg

*D044-662-041 weight and balance should be added to D044-662-011/-013 kits

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D044-662-011	BEARPAW INSTALLATION
	X		D044-662-013	BEARPAW INSTALLATION
		X	D044-662-041	WEARPLATE KIT
		4	D2274	Radius Block
8	8	4	D2529	Washer
2			D3075-1	Bearpaw
	2		D3529-1	Bearpaw
4	4		D3556-1	Clamp
		4	D3565-1	Wearplate
8	8		D3601-1	Radius Block
4	4		D4953-1	Cushion (Replaces D2182B045 Cushion)
		4	AN4-12A	Bolt
4	4		AN4-14A	Bolt
4	4		AN4-15A	Bolt
		4	AN4-16A	Bolt
8	8		NAS1149D0463J	Washer (Replaces AN960JD416 Washer)
8	8	4	MS21042L4	Nut (or MS21042-4)

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Revision: **E**

Date: 15.03.20